

Ship Aug 30

Dart Aerospace Ltd.

Date: Tuesday, 1/16/2007 11:36:58 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACK FRAME ASSEMBLY
Job Number	: 30303		
Estimate Number	: 11129		
P.O. Number	: N/A	Part Number	: D3017041
This Issue	: 1/16/2007 S.O. No. : N/A	Drawing Number	: D3017 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 30240	Material	: N/A
Written By	:	Due Date	: 1/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>01.01.16</u>		
Comment	: Est. A 01.09.19 New issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)  
4130 Tube .750 OD x.049W  
Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall  
Batch: M100543

07/08/13

2.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s)  
4130 Sheet .049 wall  
Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)  
Batch: M11612

07/08/13

3.0	D30177	Lug
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Lug  
Pick:  
Qty Part Number Description Batch  
3 D3017-7 Lug B22411

07/08/13

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
1-Cut all tubes as per Dwg D3017  
  
2-Cut end caps as per Dwg D3017  
Form as per Dwg  
3-Weld as per Dwg D3017 using Welding Jig Dt8598  
A/R Steel Rod Batch: M15684

07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 01/08/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 1/16/2007 11:36:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 30303

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill D3017-041 Using DT8621

5-Deburr

07/08/13

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

01-08-15

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-08-15

7.0

POWDER COATING

POWDER COATING



M 10484



(IX)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L

07/08/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m/07/08/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m/07/08/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(I)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/27

Job Completion



U 07/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

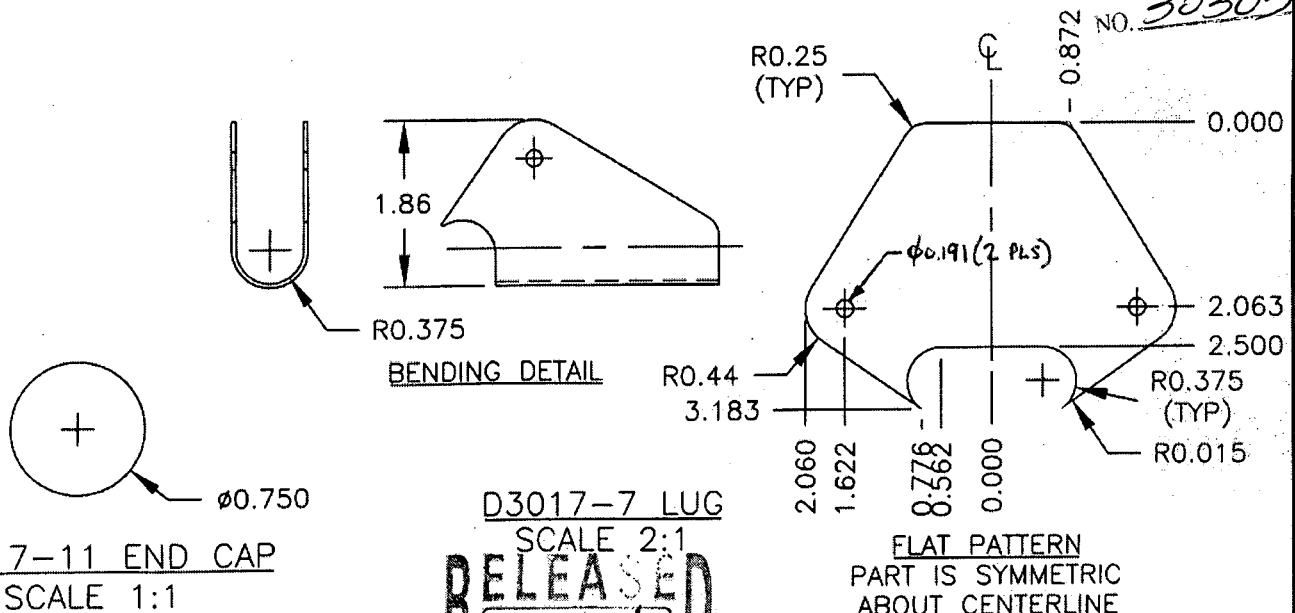
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

**NOTES**

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **30303**

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